

Date: Thursday, 12/02/2009 3:52:15 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	D350-591-133
Job Number :	45777		
Estimate Number :	10804		
P.O. Number :		Part Number :	D350591133
This Issue :	12/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	R09-011
First Issue :	/ /	Project Number :	
Previous Run :	00015	Drawing Revision :	
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	19/02/2009
Written By :		Qty:	2
Checked & Approved By :		Um:	Each
Comment :			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D350591133	Aft Maintenance Step
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Maintenance Step

Original B43692 @ CHG002

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Kit has not been opened or used by the customer.

3.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder coat white per QSI 005 4.3.5.1

M 109996

Start time: 10:30am

Oven temp: 320°F

Finish Time: 11:00am

✓ *** Ensure that the original kit is in a proper location so it does not get taken or mis-placed & be sure to put the steps back with the original kit once completed.***

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing walk as per drawing.

M 10454 A/R

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-591-133

Job Number: 45777

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/25 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure that the steps are placed back with their original kits.

S 09/02/26 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels and decals are required, with the new batch #.

JUD 0902.26 (2)

*** Ensure the original kits are with the steps***

new paperwork with ECR 09-529 added.

Re-package the steps and return to stock

Location:

CHG 002
Rev D

9/2/26

(2) Sp

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



mf 27
09-02-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 21/11/2008 1:29:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 43692

Part Number: D350591133UP

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

AL ROD BATCH: M104855

Grind => SAP 08-12-08

SP 08-12-08

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-12-08

RF 08-12-08 (2x)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslab (2x)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

DO NOT PAINT

DO NOT APPLY WING WALK

98

08-12-10 (2x)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

M-L

08/12/10

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D22301

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: 41819

SS 08/12/11 (2x)

DART

Dart Aerospace Ltd.
1270 ABERDEEN ST
HAWKESBURY ON, CANADA K6A 1K7

TC APPROVAL # 09-89

TEL: 1-613-632-5200

P/N	D350-591-133
DESC	Aft Maintenance Step
LOT	B43692
MODEL	AS350/355

CHG	CHG002
STC	SH92-6
STC	SH967NE
STC	

MADE IN CANADA

D2729-1

DART

Dart Aerospace Ltd.
1270 ABERDEEN ST
HAWKESBURY ON, CANADA K6A 1K7

TC APPROVAL # 09-89

TEL: 1-613-632-5200

P/N	D350-591-133
DESC	Aft Maintenance Step
LOT	B43692
MODEL	AS350/355

CHG	CHG002
STC	SH92-6
STC	SH967NE
STC	

MADE IN CANADA

D2729-1

Date: Friday, 21/11/2008 1:29:37 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 43692

Part Number: D350591133UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D22303

Lug



B42316

8/12/11 SD



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

Batch:

B42316 x 4

Batch Noting

SS 08/12/11 (x2)

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2606 f(s)/Unit Total : 2.5213 f(s)

Abrasion Strip 7.20" long x2

Batch:

42076

SS 08/12/11 (x2)

21.0

D2945

Step Mounting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Step Mounting Plate

Batch:

35690

SS 08/12/11 (x2)

22.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M108077

SS 08/12/11 (x2)

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch:

M106605

SS 08/12/11 (x2)

24.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch:

M107534

SS 08/12/11 (x2)

25.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Batch:

M109249

SS 08/12/11 (x2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 43692

Part Number: D350591133UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS21042L4

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total: 28.0000 Each(s)

Nut

Batch:

M108145

SS 08/12/11 (x2)

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/12/11 (x2)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev:

Rev B

SS 08/12/11 (x2)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/15

Job Completion



MF 08-12-12